

Ship Oct 15

Dart Aerospace Ltd.

Date: Friday, 9/21/2007 1:16:55 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	UPPER AND LOWER PLATE
Job Number	34803		
Estimate Number	12837		
P.O. Number	N/A	Part Number	D35241
This Issue	9/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3524 UNDER-REV
First Issue	9/21/2007	Type	MACHINED PARTS
Previous Run	33296	Project Number	N/A
Written By		Drawing Revision	N/A
Checked & Approved By		Material	N/A
Comment	Est Rev:A New Issue 07-04-18 EC Est Rev:B Now CNC Machined 07-06-28 JLM		
Due Date: 10/12/2007 Qty: 20 Um: Each			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0375X0250 364 (CJW)	6061-T6 Bar 3/8 x 2 3/4
		Comment: Qty.: 0.2365 f(s)/Unit Total: 1.1823 f(s) NO BATCH # IN COMPUTER 6061-T6 Bar .375" X 3.00" JLM Batch: M105225 DSR 07/10/01
2.0	BAND SAW	BAND SAW
		Comment: BAND SAW Cut Blanks 2.750" Long DSR 07/10/01
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA699 Rev: A & Dwg D3524 Rev: A
	2-Deburr per dwg D3443	8.8 07/10/06
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 8.8 07/10/06
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 9.1 07/10/06 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/10	3	1 scrap, the hole is too big 2 scrap, the hole is too small P.C. Human error.	Initial Chief Eng /osiall	- 2 part hole & the hole with a hole hr. Scrap - 1 part hole is 0.750 1/16" the way though - one part the part was not machine correctly Scrap all four parts and Replace	07/10/10	✓ 07/10/10	/osiall	✓ 07/10/10
						↓	↓	↓

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:16:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: UPPER AND LOWER PLATE
Job Number: 34803		Part Number: D35241
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1  Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 M 07-10-10 20
7.0	POWDER COATING 	POWDER COATING M 102316 Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 m-k 07/10/11 20x
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION M 07-10-11 20
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 7/10/11 20 54
10.0	QC21 	FINAL INSPECTION/W/O RELEASE 7/10/11 20 54 D 07/10/11 20
Job Completion 		U 8/10/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

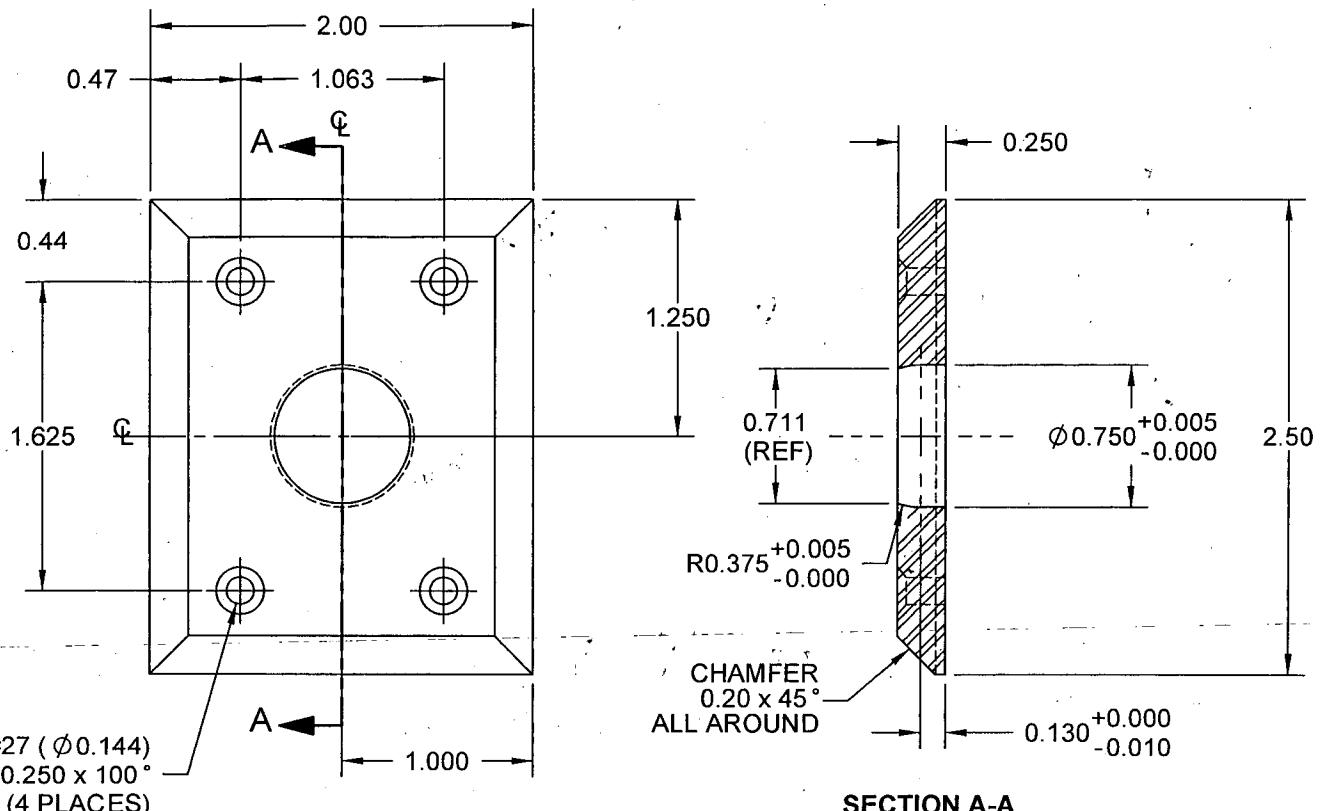
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED CE	APPROVED MM	DRAWING NO. D3524	REV. A	SHEET 1 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1	
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE		



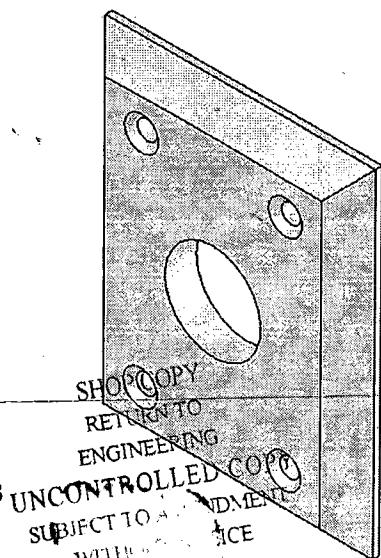
SECTION A-A

D3524-1 LOWER PLATE

RELEASED
07.08.03

NOTES:

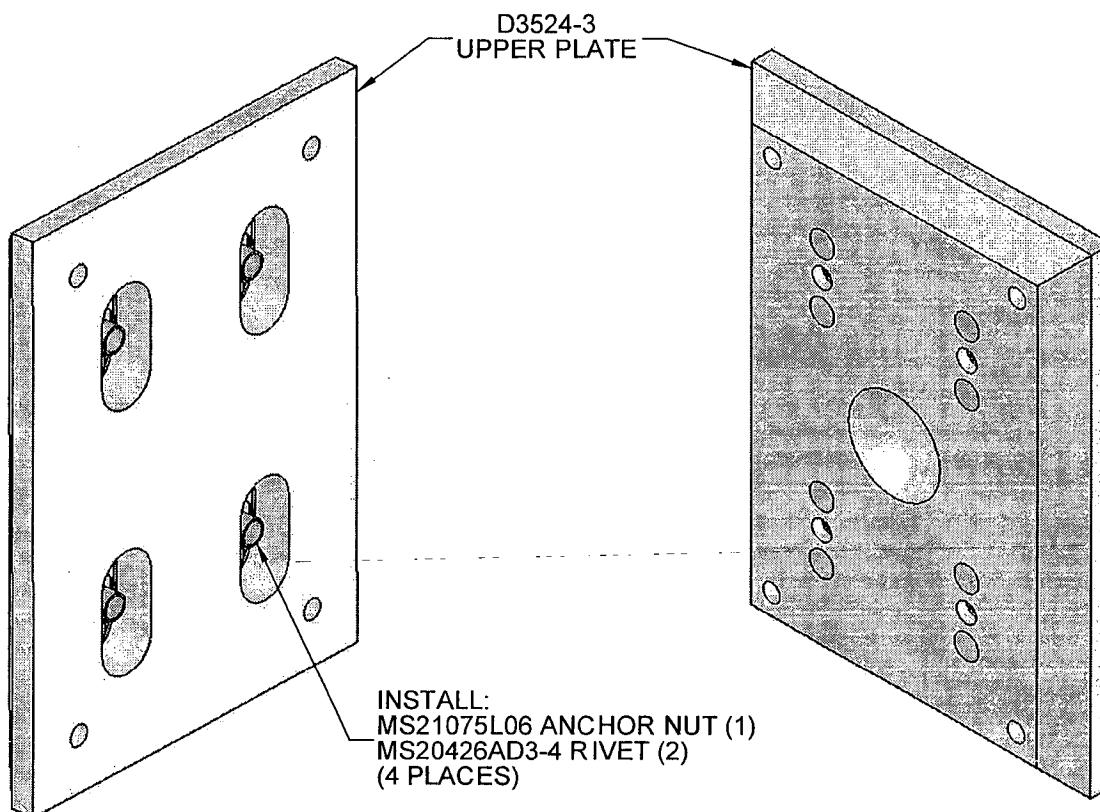
- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8-OR AMS 4115/4116/4117/4128-OR
QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT \mathbb{Q}





DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED H	DRAWING NO. D3524
DATE 07.07.24		TITLE UPPER AND LOWER PLATE

REV. A
SHEET 2 OF 3
SCALE
1:1



RELEASED
07.08.03

D3524-041 UPPER PLATE ASSEMBLY

PARTS LIST:

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE-ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

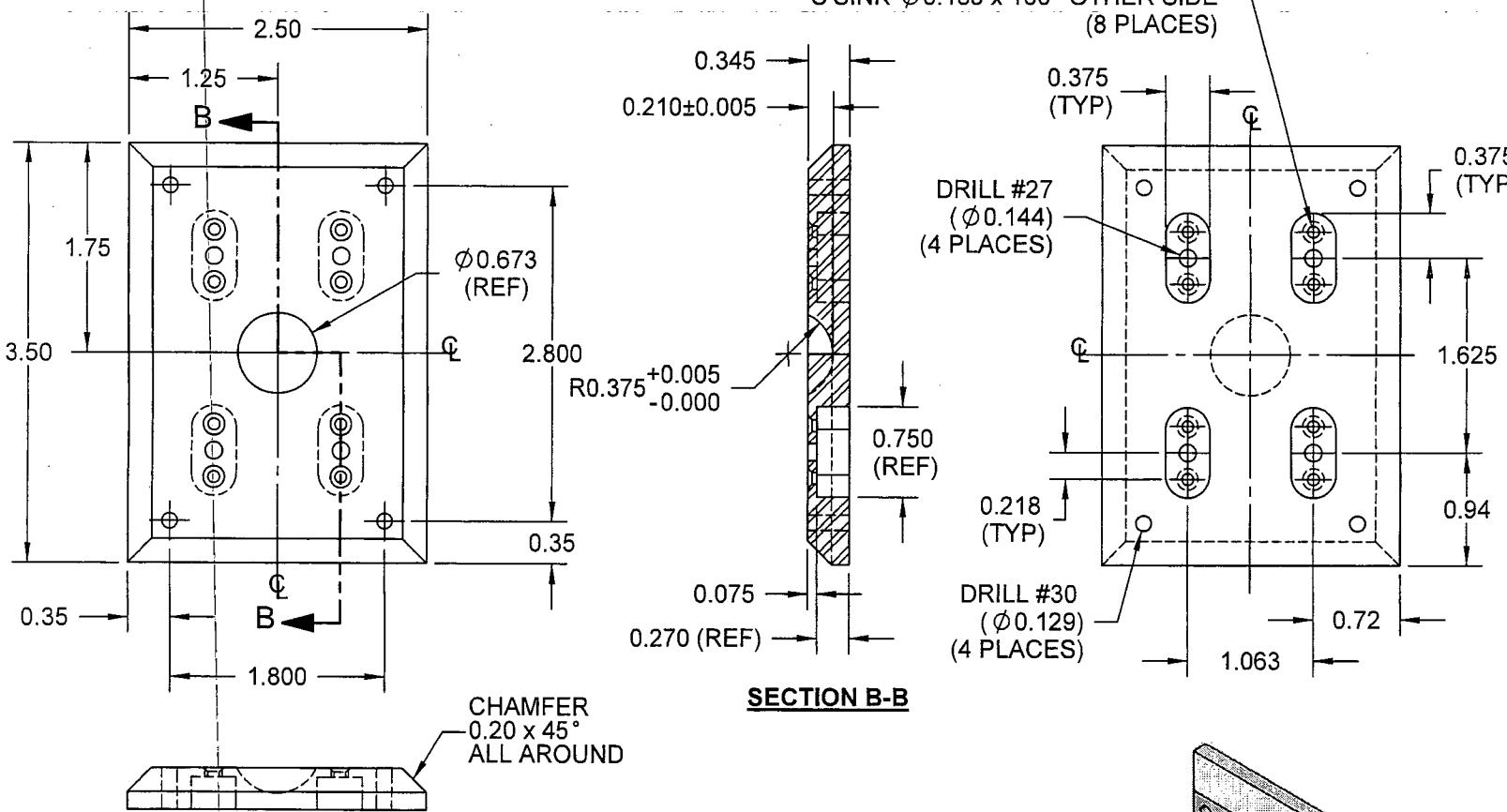
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DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED CE	APPROVED <i>[Signature]</i>	DRAWING NO. D3524
DATE 07.07.24	TITLE UPPER AND LOWER PLATE	REV. A SHEET 3 OF 3 SCALE 2:3



D3524-3 UPPER PLATE

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT \mathbb{C}

RELEASED
IN B77-58-63
W/1
NO.

DART AEROSPACE LTD

Work Order: 34803

Description:

Part Number: 3524-1

Inspection Dwg:D3524

Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:

87

Audited by:

Prototype Approval:

Date:

07/10/06

Date: 67-13-64

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	